

Date: Wednesday, 9/13/2006 4:34:06 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 SKIDTUBE ASSEMBLY RH UNDER REVIEW
Job Number	: 28539		
Estimate Number	: 10265	Part Number	: D350636012
P.O. Number	: N/A	Drawing Number	: D2750
This Issue	: 9/13/2006	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: D
First Issue	: N/A	Material	: N/A
Previous Run	: 27961	Due Date	: 9/30/2006
Written By	: <u> </u>	Qty:	1 Um: Each
Checked & Approved By	: <u> </u>		
Comment	Est Rev: I 02-09-25 Rearranged procedure steps KJ Est Rev: J 06-03-29 As per Rev D EC Est Rev: J 06-07-13 As per dsi9343 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-012 CHG 002

KS 06 09 15 ①

2.0	D26003BENT	Extrusion Bent
-----	------------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

B26787

Pm 06-9-19 ①

3.0	D2744	Fwd Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch:

B25839

BE

06-10-02

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end Pm 06-9-20 ①

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 & DT8863 drilling Pm 06-9-20 ①
holes labelled "A" only.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut Pm 06-9-20 ①
as per dwg D2750.

W/O:		WORK ORDER CHANGES					
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QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Drill pilot holes for Detail B using DT8330

5-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.250" ***Make sure that wearplate holes are on bottom of tube*****

6-Open up holes of Detail A to 0.250" (total of 2 holes per side)

7- Countersink all fwd wearshoe holes (total of 19 holes per side) DO NOT C'SINK THE LAST AFT HOLES (total of 2 per side for blade fitting) as per dwg D2750.

8-Countersink Detail A as per dwg D2750.

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod *M101655 BE 06-10-02*

10-Grind welds flush as per Dwg D2750

5.0 QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

Batch: *B28256*

9.0

D34901

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch: *B28874*

pmc 06-9-2011

pmc 06-10-10

pmc 06-10-10

pmc 06-10-11

pmc 06-10-12

BE 06-10-12

pmc 06-10-12

BE 06-11-01

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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 28539

Part Number: D350636012

Job Number:



Seq. #: Machine Or Operation: Description :

10.0 D34903 CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch:

B 27754

BE 06-11-01

①

11.0 D2743 Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Crossbolt Spacer

Batch:

B 27741

BE 06-11-01

①

12.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes for Detail B, "hole size W" and blade fitting location holes to 0.500" (total of 9 holes per side) as per dwg D2750. *Pm 06-9-2001* *Done at seq. #1*

2-Open up holes of Detail V & Detail C to 0.625" (total of 8 holes per side) as per dwg D2750. *Pm 06-10-12*

3-Open up holes of Detail D to 0.750" (total of 4 holes per side) as per dwg D2750. *Pm 06-10-12*

4-Chamfer holes of Detail V, Detail C, Detail D and hole size "W" per dwg D2750 (welding instructions on sheet 4) *Pm 06-10-12*

5-Deburr and blow out all chips from inside of tube. *Pm 06-10-12*

6-Bond web D2739 in place as per QSI 015

A/R

Sikaflex-291

batch: *M 10/653*

exp. date: *06-10-21*

Pm 06-10-12

7- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 4)

A/R

Aluminum Rod

batch:

M 10/655

BE 06-11-01

①

8-Grind welds flush as per Dwg D2750 *M 06/11/01* *BE*

9-Spot face ground handling holes section J-J (total of 4 places per side) as per dwg D2750

BE 06/11/01

10-Deburr holes

BE 06/11/01

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Job Number: 28539

Part Number: D350636012

Job Number:



Seq. #: Machine Or Operation: Description :

13.0 QC5/9 WELD INSPECTION



Comment: Inspect weld and work to Step 20

06/11/06 (1)

14.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

M101575
y 06/11/10 R1

15.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION
Inspect for foreign object per QSI 024

06/11/10

16.0 NAS1330S3KB166 INSERT



Comment: Qty.: 42.0000 Each(s)/Unit Total: 42.0000 Each(s)

INSERT

Batch: m102120 (26) 16x m102644

06/11/13 (1)

17.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
1-Install inserts as per dwg D2750

a.m 06/11/13 (1)

18.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Inspect Inserts

FC 06 11 13 (1)

19.0 D26483 Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Wearpad

Batch: B27169

20.0 D265613 Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearplate

Batch: B27731

a.m 06/11/13

W/O:		WORK ORDER CHANGES					
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Job Number: 28539

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B26206

22.0

D2746

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B28257

23.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: B27862

24.0

D3488042

BLADE FITTING ASSEMBLY, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: B28319

25.0

D3492041

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B28579

26.0

D3492043

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B28580

06/11/14 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 28539

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN3C5A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

Bolt

Batch: M102472

11X102552

28.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M19522

29.0

AN3C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Batch: 2X M10124 2X M10253

30.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Batch: M101943

31.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BOLT

Batch: M102180

32.0

AN960C10L

washer



Comment: Qty.: 46.0000 Each(s)/Unit Total: 46.0000 Each(s)

washer

Batch: M101340

33.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: M100186

a.m. 06/11/14 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 28539

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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34.0	MS210436	NUT
------	----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: M101537

35.0	MS21083C8	NUT
------	-----------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: M100186

36.0	NAS1515H3L	WASHER
------	------------	--------



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

WASHER

Batch: M101418

37.0	NAS1515H8L	WASHER
------	------------	--------



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

WASHER

Batch: M102535

a.m

02/11/14

(1)

38.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
------	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"

batch: M101915

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M102107

EXP DATE: 02/07

4-Coat all exposed fasteners with "LPS Procyon"

batch: M17168

a.m

02/11/14

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

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Job Number: 28539

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Joe 11-14 D

40.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

41.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: *327968*

42.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: *M100186*

43.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: *M100186*

44.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: *M102473*

45.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: *M102515*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 04/11/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 28539

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

46.0

D34931

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

✓ WASHER

B 27835

47.0

D35321

spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

✓ spacer

B 27894

48.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

P B 06/11/17 ①

49.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-012

R

P 06/11/17

50.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

P 06/11/17 ①

Job Completion



n 06.11.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. D SHEET 1 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740	
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133/9157	

RELEASED
06-02-07 *TH*

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
5	5	5	5	D2648-3	WEARPAD
1	1	1	1	D2656-13	WEARSHOE
1	1	1	1	D2656-35	WEARSHOE
1	1	1	1	D2746	WEARSHOE
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
2	2	2	2	AN8C21A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
4	4	4	4	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
3	3	3	3	MS21083C8	NUT
42	42	42	42	NAS1330S3KB166	INSERT
46	46	46	46	NAS1515H3L	WASHER
12	12	12	12	NAS1515H8L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28539

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DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D2750	REV. D SHEET 2 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

RELEASED
06-02-07

GENERAL NOTES:

1. ALL DIMENSIONS ARE IN INCHES
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E, F-F, AND R-R.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL NAS1330S3KB166 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'E' SIZE HOLES ($\emptyset 0.250$ - $\emptyset 0.257$) FOR WEARSHOE INSERTS. C'SINK $\emptyset 0.391 \times 100^\circ$ AND INSTALL INSERTS
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3-5A/AN3-7A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12. APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES

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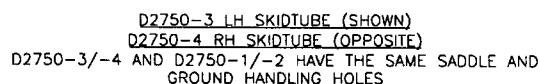
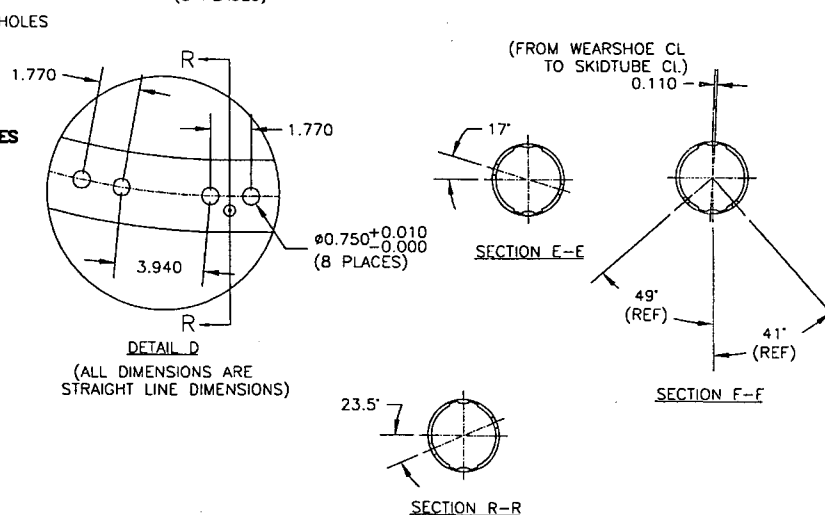
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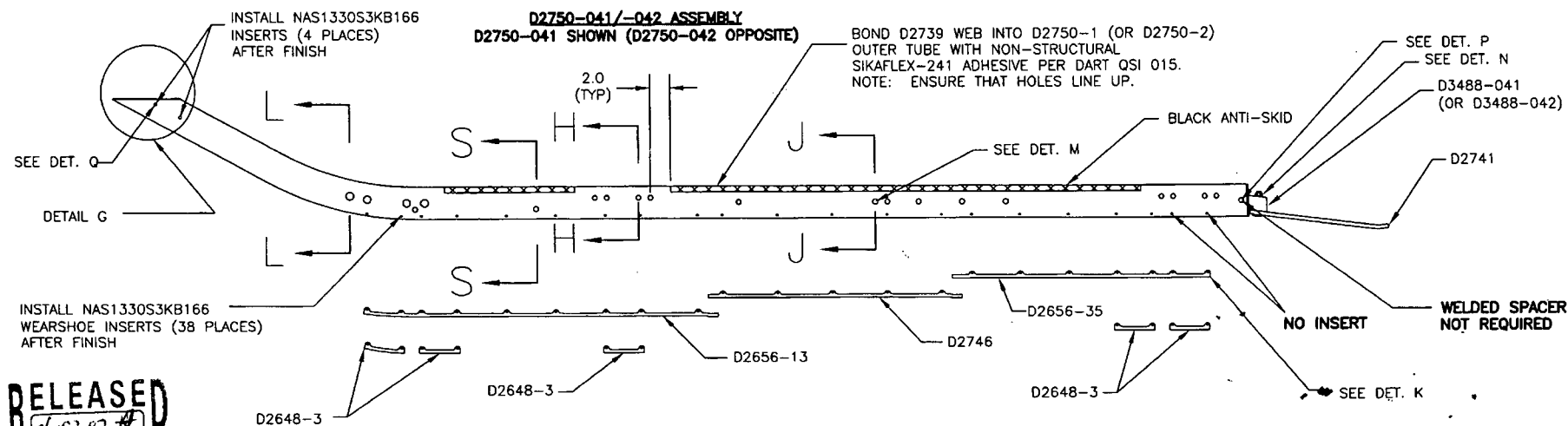
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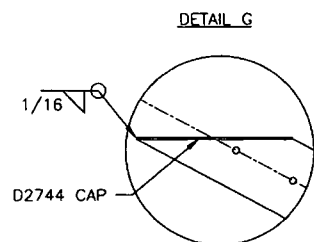


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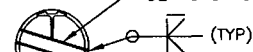
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#H	#H	D2750	SHEET 3 OF 5	
DATE	TITLE			
06.01.05	350 SKIDTUBE ASSEMBLY			



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 06-02-07 #



SECTION H-H D2743 SPACER (REF)



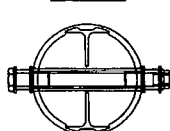
SECTION J-J



WELDING INSTRUCTIONS

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

DETAIL M



- AN6-44A BOLT (1)
 D2745 BUSHING (2)
 NAS1515H8L WASHER (2)
 MS21043-6 NUT (1)
 (4 PLACES)
NOTE: INSTALL WASHER BETWEEN SKIDTUBE AND BUSHING

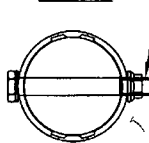
DETAIL K



- USE AN3C7A BOLTS FOR INSTALLING AFT D2648-3 WEARPAD (4 PLACES)

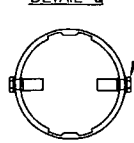
- AN3C5A BOLT (1)
 AN960JD10L WASHER (1)
 NAS1515H3L WASHER (1)
 (38 PLACES)

DETAIL P

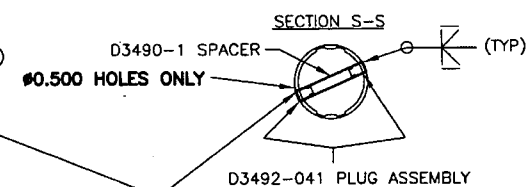
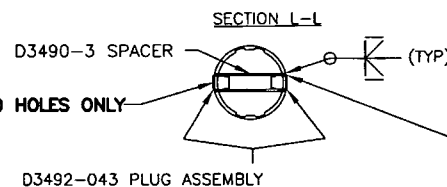


- AN8C35A BOLT (1)
 AN960C816L WASHER (2)
 NAS1515H8L WASHER (2)
 MS21083C8 NUT (1)

DETAIL Q



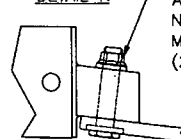
- AN3C6A BOLT (1)
 AN960C10L WASHER (1)
 NAS1515H3L WASHER (1)
 (4 PLACES)



WELDING INSTRUCTIONS

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES OR INSERT D3490-3 SPACER (4 PLACES) INTO Ø0.750 HOLES
3. WELD INTO PLACE
4. GRIND FLUSH
5. INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER OR INSERT D3492-043 PLUG ASSEMBLY (8 PLACES) INTO D3490-3 SPACER ON BOTH ENDS

DETAIL N



- AN8C21A BOLT (1)
 AN960JD816L WASHER (1)
 NAS1515H8L WASHER (1)
 MS21083C8 NUT (1)
 (2 PLACES)

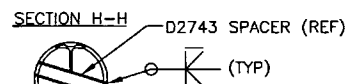
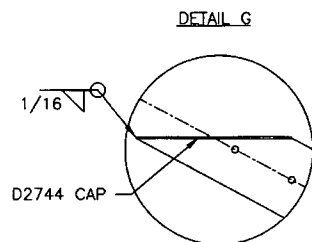
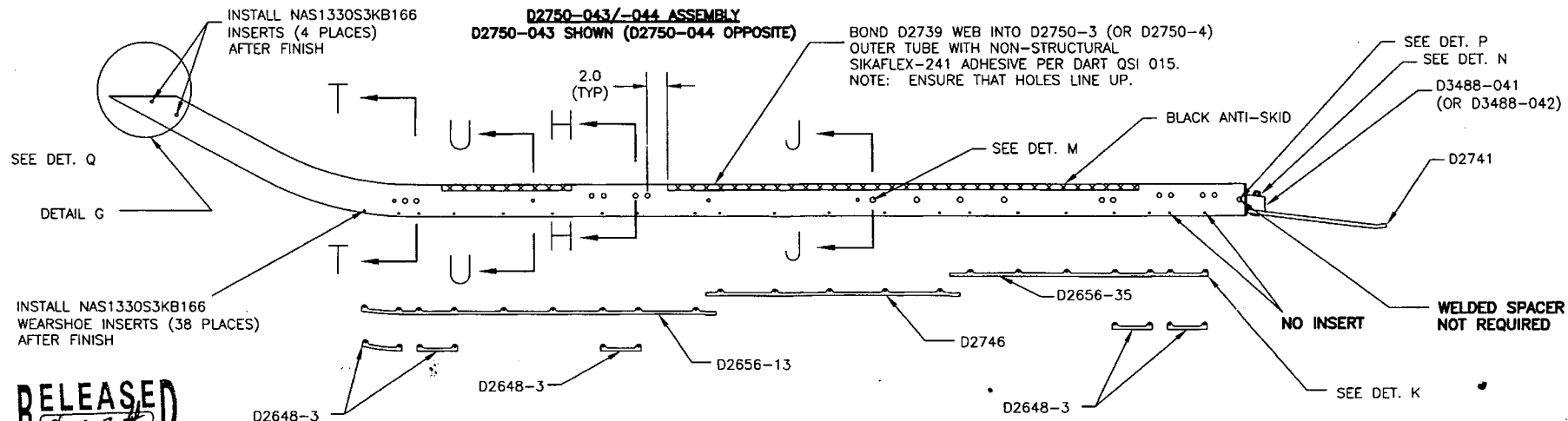
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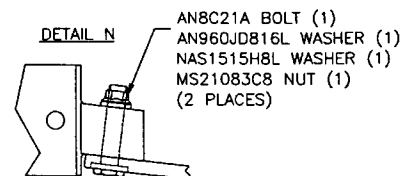
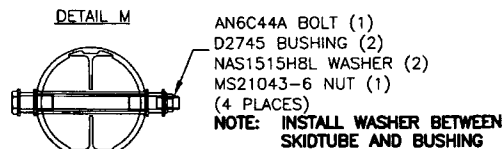
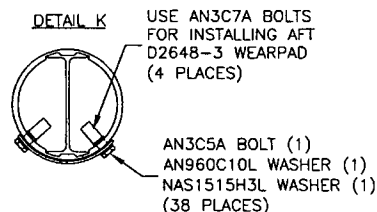
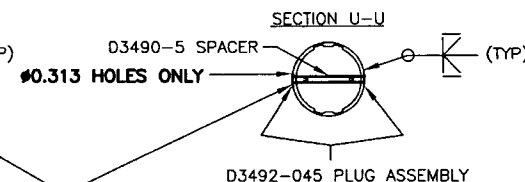
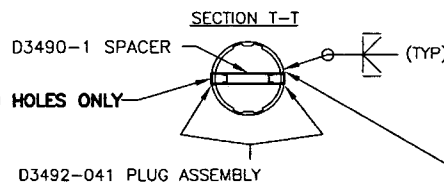
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D2750-043/-044 ASSEMBLY
D2750-043 SHOWN (D2750-044 OPPOSITE)

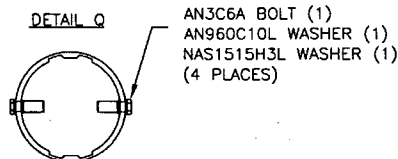
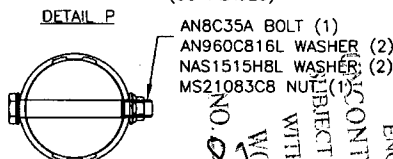
BOND D2739 WEB INTO D2750-3 (OR D2750-4)
OUTER TUBE WITH NON-STRUCTURAL
SIKAFLEX-241 ADHESIVE PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.



- SECTION J-J**
- WELDING INSTRUCTIONS**
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D2743 SPACER
 3. WELD INTO PLACE
 4. GRIND FLUSH
 5. DRILL OUT SPACER TO Ø0.484
 6. SPOT FACE Ø0.750 (SECTION J-J ONLY)



- WELDING INSTRUCTIONS**
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D3490-5 SPACER (4 PLACES) INTO Ø0.313 HOLES OR INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES
 3. WELD INTO PLACE
 4. GRIND FLUSH
 5. INSERT D3492-045 PLUG ASSEMBLY (8 PLACES) INTO D3490-5 SPACER OR INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER ON BOTH ENDS



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AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number A350636 011 / B29200

TEST WELDS REQUIRED

BASE METAL	<u>Alum</u>	WELDING PROCESS	<u>Tig</u>
Penetration	Complete <input type="checkbox"/> Partial <input checked="" type="checkbox"/>	Single Weld <input checked="" type="checkbox"/> Double Weld <input type="checkbox"/>	
Current	AC <input checked="" type="checkbox"/> DC <input type="checkbox"/>	Backing	YES <input type="checkbox"/> NO <input checked="" type="checkbox"/>
	Position	Vertical	Down <input type="checkbox"/> Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/> 2G <input type="checkbox"/> 3G <input type="checkbox"/> 4G <input type="checkbox"/>		
Tube Groove	1G <input type="checkbox"/> 2G <input type="checkbox"/> 5G <input type="checkbox"/> 6G <input type="checkbox"/>		
Sheet Fillet	1F <input type="checkbox"/> 2F <input type="checkbox"/> 3F <input type="checkbox"/> 4F <input type="checkbox"/>		
Tube Fillet	1F <input type="checkbox"/> 2F <input type="checkbox"/> 4F <input type="checkbox"/> 5F <input type="checkbox"/>		
Crossbolt Spacer	Welded into		Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/10/30 Qualifier David David